

Nr 04100 21416

Zakład Laserowej Obróbki Metali
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DEPARTMENT OF LASER METALWORKING

The Department is active in Kraków and Mielec

The Kraków Plant



The Mielec Plant

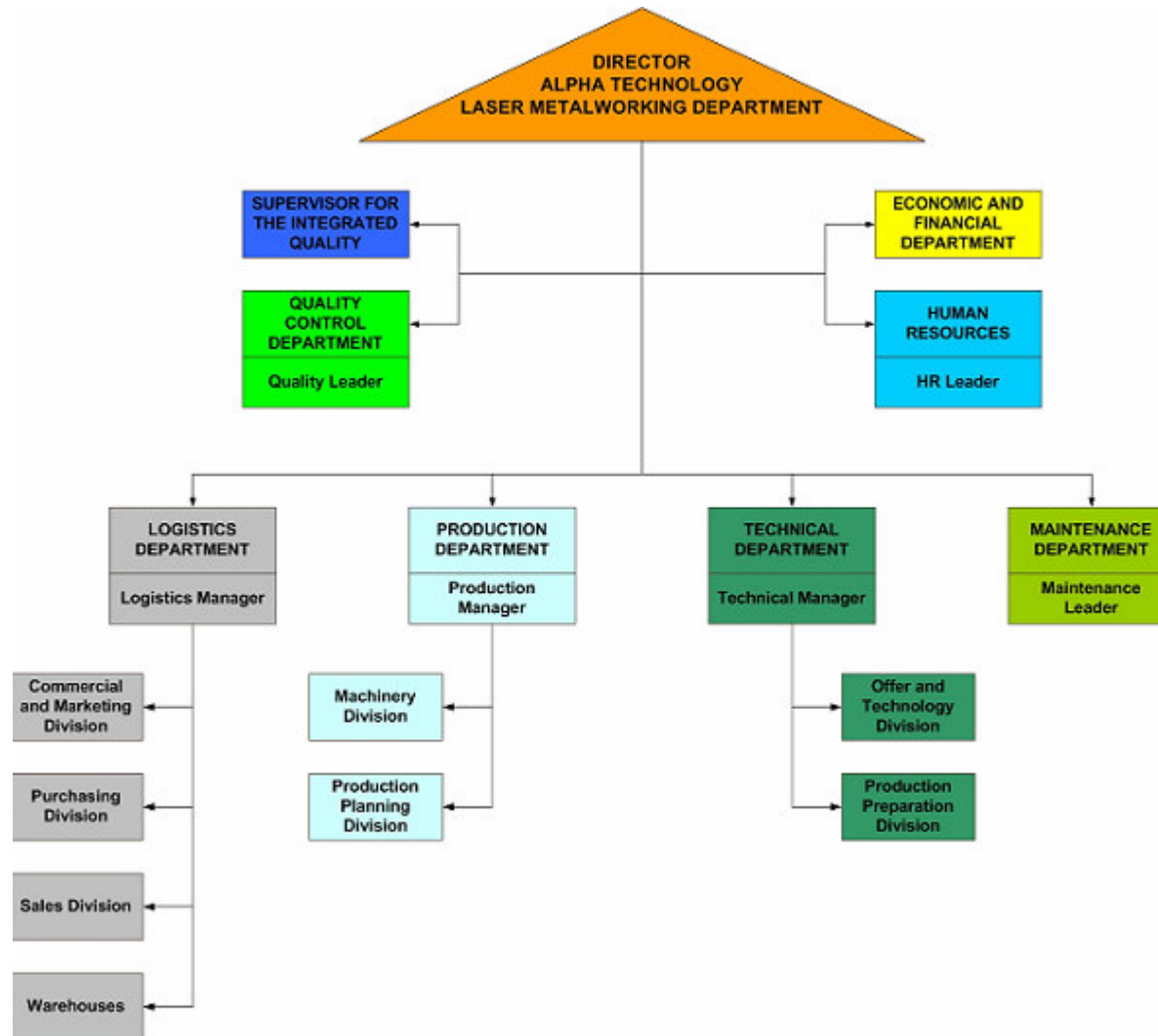


The Kraków Plant

offers services in the following branches

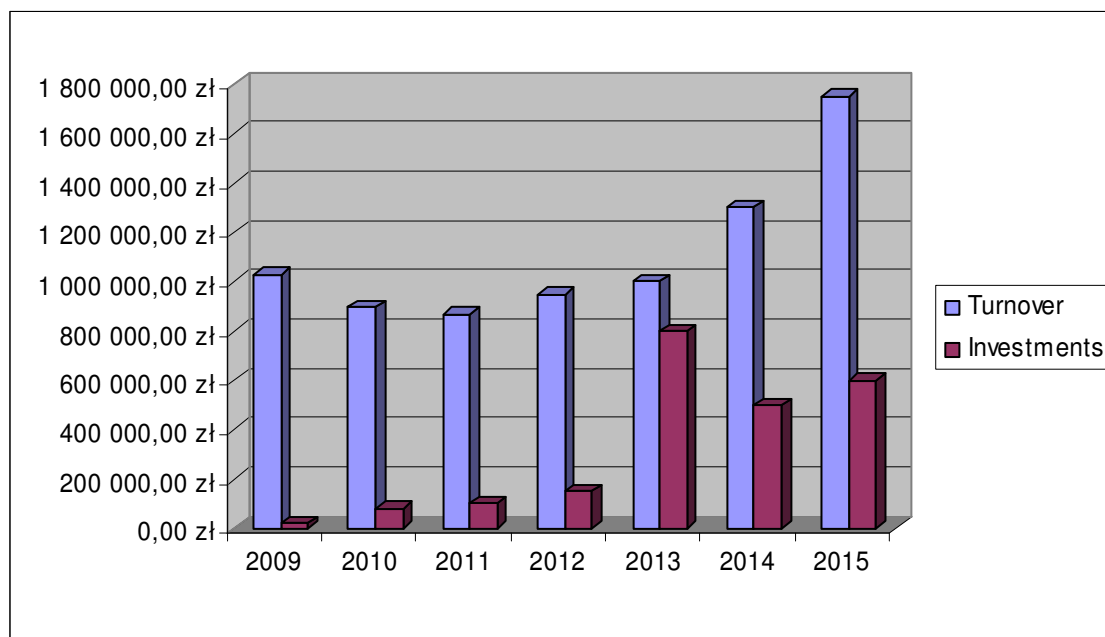
1. Laser cutting of metal 2 x 4 m plates
2. CNC bending of metal plates
3. MIG/MAG/TIG welding
4. Design and manufacture of Kärcher GmbH sweepers
5. Design and manufacture of small industrial tow tractors
6. Motor driven mini cars for children
7. Trade Agency of the Mädler Company
8. Design and manufacture of power generator sets

MANAGEMENT ORGANISATION CHART





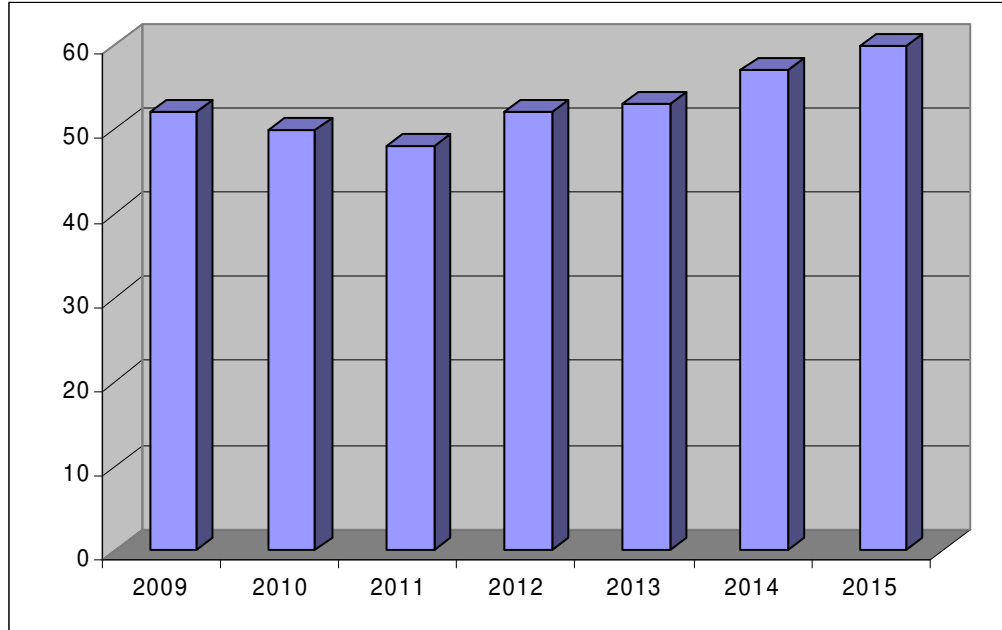
Turnover and Investments and our plans for the future



	Turnover	Investments
2009	1 030 023,18 zł	20 000,00 zł
2010	894 408,91 zł	80 000,00 zł
2011	868 577,34 zł	100 000,00 zł
2012	950 000,00 zł	150 000,00 zł
2013	1 000 000,00 zł	800 000,00 zł
2014	1 300 000,00 zł	500 000,00 zł
2015	1 750 000,00 zł	600 000,00 zł



Employment and our plans for the future



	Employment
2009	52
2010	50
2011	48
2012	52
2013	53
2014	57
2015	60



3x1,5m plates



3x1,5m plates



4x2m plates



Structural steel up to 20mm thickness

Stainless steel up to 15mm thickness

Aluminium up to 10mm thickness

The laser cutting employed in our laser cutting plants enables us to offer:

- Cutting out of freely shaped parts in thin and thick plates.
- Production of short and long runs from different materials, with low cost and in short time.
- Production of ready to assemble parts, without the necessity of trimming.
- Cutting out of holes of a diameter equal to 0.4 the plate thickness.
- Engraving and pointing.



Laser cutting machines - compilation

Machine location	Kraków	Kraków	Mielec	Mielec
Manufacturer	Trumpf	Trumpf	Trumpf	Trumpf
Type	Trumatic L3030	Trumatic L4030	Trumatic L3030	Trumatic L4030
Manufacturing year	2004	2005	2007	2007
Laser power [W]	4000	4000	4000	4000
Working area [mm]	3000x1500	4000x2000	3000x1500	4000x2000
Accuracy +/- [mm]	up to 0,1	up to 0,1	up to 0,1	up to 0,1
Max. structural steel thickness [mm]	20	20	20	20
Max. stainless steel thickness [mm]	15	15	15	15
Max. aluminium thickness [mm]	10	10	10	10



- ❑ Highest bending accuracy thanks to the precise system of the press ram movement measurement.
- ❑ Very high accuracy and repeatability of the bend angle.
- ❑ Automatic, stepless sag elimination system.
- ❑ Rich choice of universal and special tooling.
- ❑ A big dimensioned press throat enables carrying out so called “deep” bends.



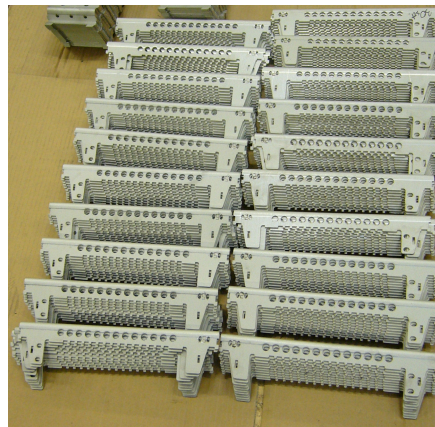
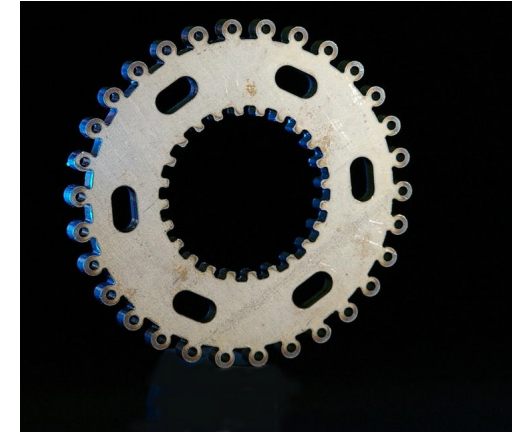
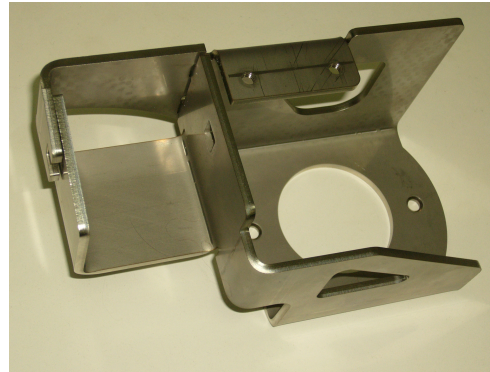
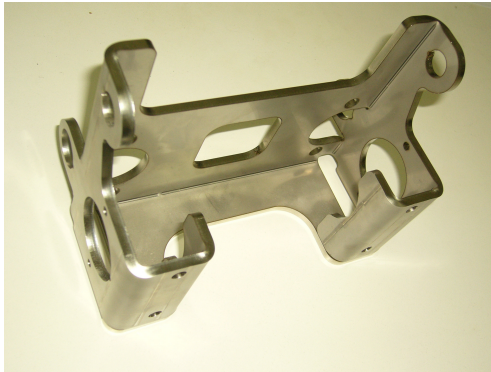


CNC bending machines - compilation

Machine location	Kraków	Kraków	Mielec
Manufacturer	EHT	Trumpf	Trumpf
Type	TrumaBend S300-40	TruBend 5130	TruBend 5130
Manufacturing year	2005	2008	2007
Press force [kN]	3000	1300	1300
Bending length [mm]	4000	3230	3230
Throat [mm]	620	420	420
Max. Working speed [mm/s]	5	10	10
Accuracy +/- [mm]	up to 0,1	up to 0,1	up to 0,1



Examples of Sheet Metal Products





Up to date MIG/MAG/TIG welding equipment and professional welding stands enable high quality welding of:

- ❑ Structural steel.
- ❑ Stainless steel.
- ❑ Aluminium.





Welding machines - compilation

Machine location	Kraków	Kraków	Mielec	Mielec
Manufacturer	Selco	OZAS	Selco	OZAS
Type	Genesis 352 PSR	OPS-400	Genesis 352 PSR	OPS-400
Manufacturing year	2006	1992	2007	1992
Number of piece	1	1	2	1
Welding process	MIG/MAG manual/automat	MIG/MAG	MIG/MAG manual/automat	MIG/MAG
	TIG DC Lift start welding		TIG DC Lift start welding	
	Air Carbon Arc gouging		Air Carbon Arc gouging	
	MMA stick welding		MMA stick welding	



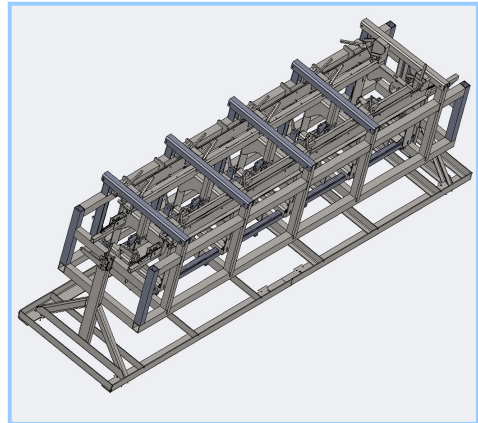
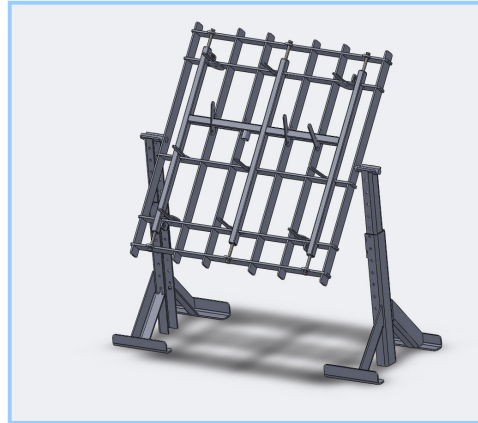
Details of the Welder Approval Test Certificate

- ❑ Our welders are certificated by INSTITUTE OF WELDING – POLAND
- ❑ All welding processes are projected and managed by experienced people
- ❑ The table shows the specification of our welding activity

	Range of qualification
Welding process(es)	141,131
Plate of pipe	P, T:D=150mm
Type of weld	FW
Material group(s)	1.1, 1.2, 1.4, 8, 9.2, 9.3, 10, 21, 22
Welding consumables/Design	S
Material thickness (mm)	>=3
Welding position	FW: PA, PB
Weld details	sl, ml
Designation(s)	EN 287-1 141 P FW 1.1 S t10 PB ml
	EN 287-1 141 P FW 8.1 S t5 PB ml
	EN ISO 9606-2 141 P FW 22 S t10 PB ml
	EN 287-1 131 P FW 8.1 S t5 PB ml

Design and building welding fixture

- ❑ We design professional welding fixture which are used for serial production
- ❑ Our projects are supported by advanced 3D software like Solidworks so we are able to built very high quality equipment



Additional equipment

- Band saw machine
- Drilling machine
- Bevelling machine
- Air Driven Tapping Machine





Additional equipment - compilation

The Kraków Plant

Name	Bevelling machine	Name	Band saw machine
Manufacturer	Gerima	Manufacturer	Pegas & Gonda
Type	PAM Typ 2	Type	PEGAS 250X315 GH-LR
Manufacturing year	2006	Manufacturing year	2010
Bevel width	1 - 15mm		
Bevel angle	30-60		
Spindle speed	1000-6000 rpm		
Milling head	fi=100mm		
Inserts	8		
Name	Air Driven Tapping Machine	Name	Drilling machine
Manufacturer	Gamor	Manufacturer	TOP
Type	TA-N/20	Type	MEX - 35
Manufacturing year	2010	Manufacturing year	2008
Capacity	M4 - M20	Max diameter drilling holes (steel)	30 mm
Work range	max: 1950 min: 200	Capacity	M14/M16
Speed	150/400 RPM	Spindle speed	50 - 2500 obr/min
Additional information	Vertical/Horizontal tapping	Working area	550x500
	Centring device magnet		



General review

EQUIPMENT COMPILATION	Location	
	Kraków	Mielec
	Number of piece	Number of piece
Laser cutting machines	3	2
CNC bending machines	2	1
Welding machines	2	3
Drilling machines	2	1
Bevelling machine	1	0
Band saw machine	1	1
Air Driven Tapping Machine	1	1



Design and manufacture of Kärcher GmbH sweepers



Sweeper KMR 1700





Motor driven mini cars for children.



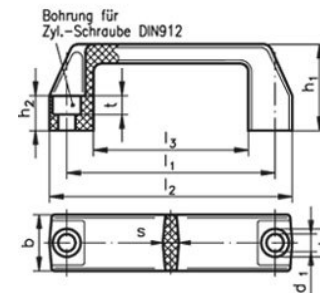
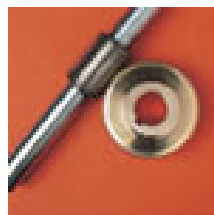
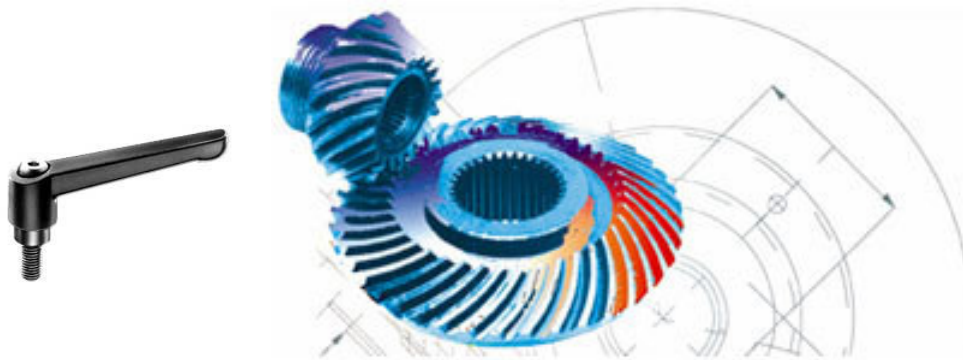
- For children of 7 to ...teen years of age.
- Four stroke HONDA engine.
- Manual gearbox -2 speeds + reverse.
- Steering wheel.
- Gear lever.
- Direction indicators.
- Lights switch.
- Rear view mirror.
- Clutch, brake and accelerator pedals.



Trade Agency of the Mädlar Company

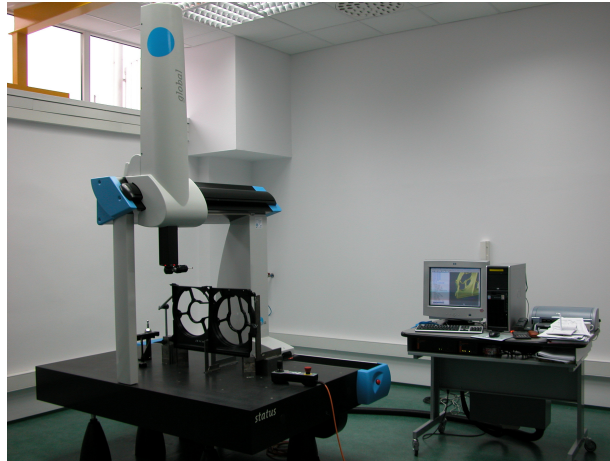
- ❑ Machine drive and transmission components.
- ❑ Fasteners and pneumatic elements.
- ❑ Clamping fixtures, etc.

As trade agents of the world renowned MÄEDLER Company we are able to quickly deliver over 20,000 various machinery components.





QUALITY CONTROL DEPARTMENT

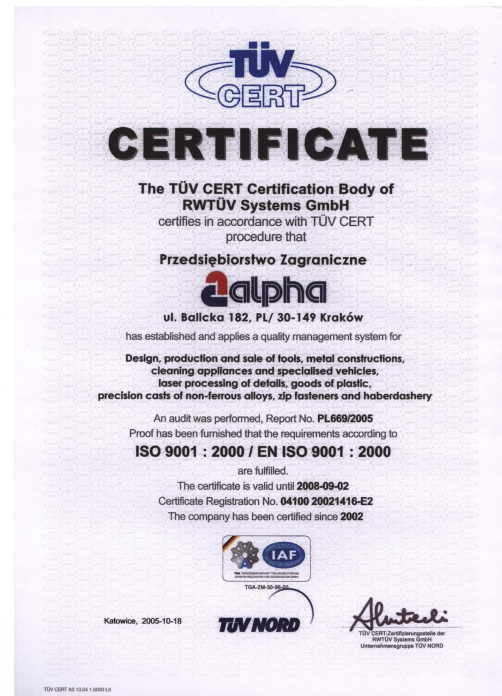


Our certificates





Our Certificates



URKUNDE



Fertigungsstätten-Besichtigung am 26. Juli 2006 aufgrund der Vereinbarungen in der Prüf- und Zertifizierungsordnung.

Lizenzinhaber:

Alfred Kärcher GmbH & Co. KG
Reinigungssysteme
Alfred Kärcher Straße 28-40

D - 71364 Winnenden

Für die von TÜV PRODUCT SERVICE zertifizierten Produkte wird gemäß den Anforderungen der Prüf- und Zertifizierungsordnung eine einwandfreie und gleichmäßige Fertigungsqualität sichergestellt. Die in der Fertigung angewandten und dokumentierten Qualitätssicherungsverfahren wurden dafür als geeignet befunden.

Fertigungsstätte:

ALPHA PRZESIEBIORSTWO ZAGRANICZNE
ZAKLAD LASEROWEJ OBRÓBKII METALI
Ul. Stawowa 142

PL 31-346 KRAKÓW

Geprüfte Geräte:

Kehrsaugmaschine

Die Fertigungsstättenbesichtigung wurde entsprechend den Vorgaben von TÜV PRODUCT SERVICE durchgeführt. Die Urkunde ist 12 Monate gültig, beginnend mit dem Datum der Besichtigung.

Divina, 27. Juli 2006

Kováč
Dipl.-Ing. Samuel Kováč





SOFTWARE

LOGISTIC



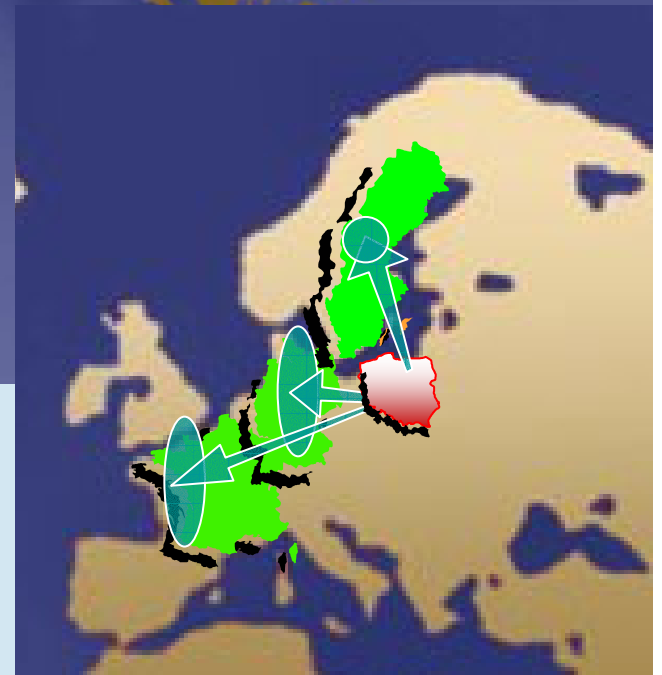
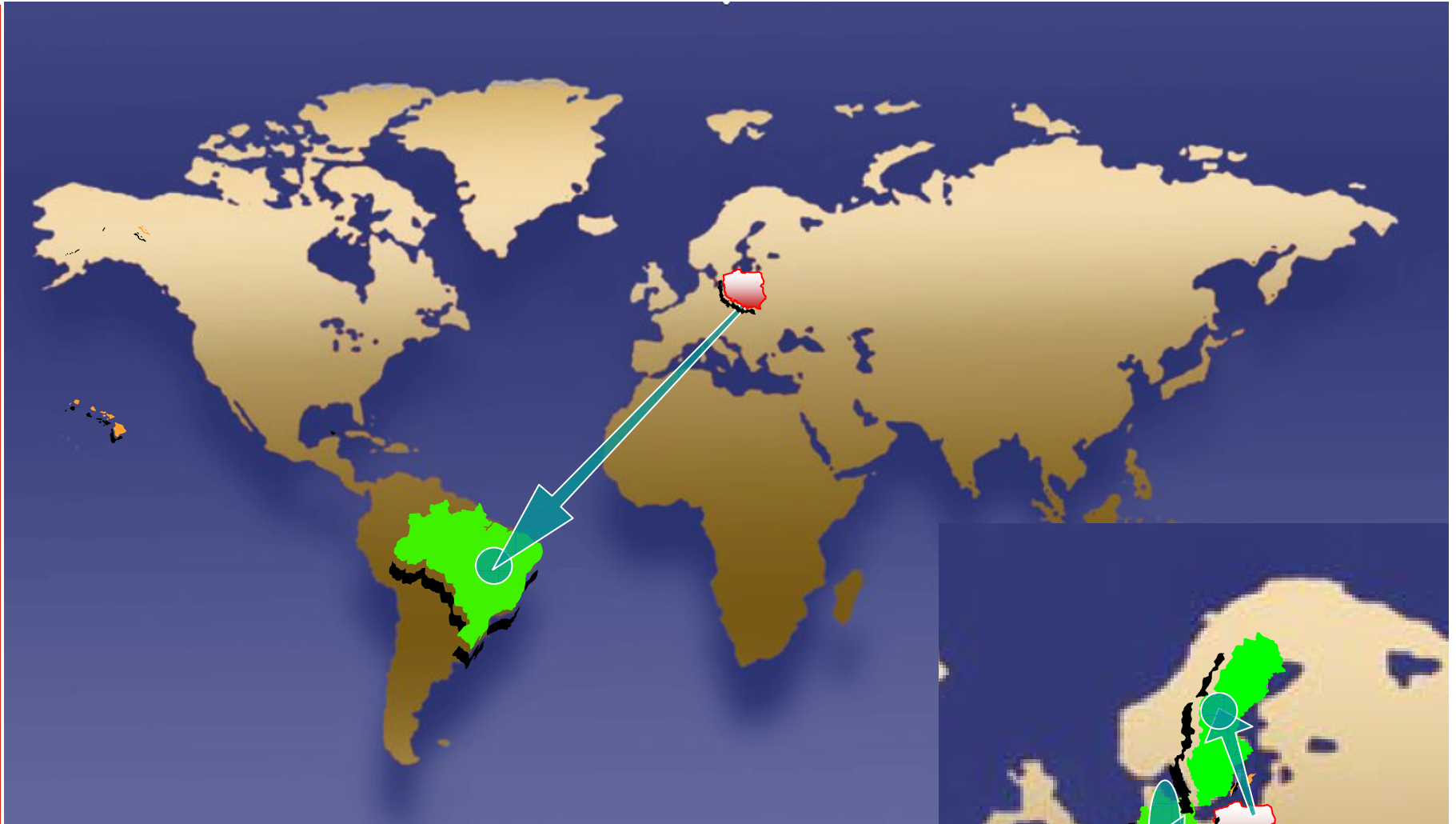
CONSTRUCTION AND DESIGN

AutoCAD®





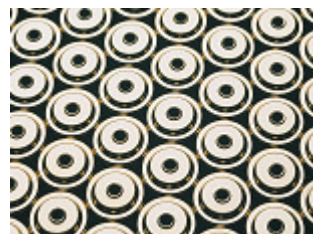
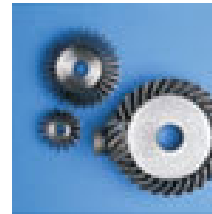
LOCALISATION OF OUR MAIN CLIENTS





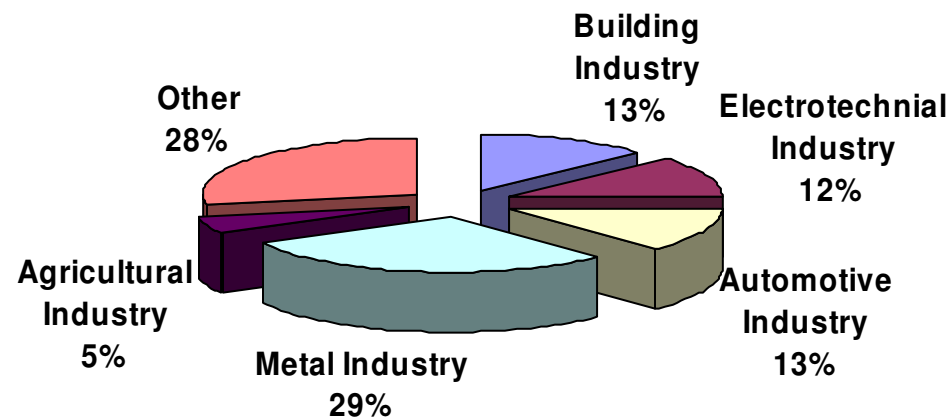
Our products buy company from

- Building Industry
- Electrotechnical Industry
- Agricultural Industry
- Automotive Industry
- Metal Industry





Shares in sales volumes





OUR CLIENTS





Thank you for your attention

For more information please check:

www.alpha.krakow.pl